

# Work Order ID 68334



Page 1

Tuesday, April 12, 2011 10:01:11 AM

|                          |                  |  |               |       |  |
|--------------------------|------------------|--|---------------|-------|--|
| Item ID: D3065-5         | Accept           |  | Setup         | Start |  |
| Revision ID:             |                  |  |               | Stop  |  |
| Item Name: Step Leg      |                  |  |               |       |  |
| Start Date: 4/12/2011    | Start Qty: 80.00 |  | Cust Item ID: |       |  |
| Required Date: 4/18/2011 | Req'd Qty: 80.00 |  | Customer:     |       |  |
| Reference:               |                  |  |               |       |  |

|            |                        |                      |            |       |     |       |  |
|------------|------------------------|----------------------|------------|-------|-----|-------|--|
| Approvals: | Process Plan: <u>H</u> | Date: <u>4-04-12</u> | Tooling:   | Date: | Run | Start |  |
|            | QC:                    | Date:                | SPC (Y/N): | Date: |     | Stop  |  |

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

|          |              |  |  |  |  |  |  |  |  |
|----------|--------------|--|--|--|--|--|--|--|--|
| Draw Nbr | Revision Nbr |  |  |  |  |  |  |  |  |
| D3065    | Rev B        |  |  |  |  |  |  |  |  |

|                   |                              |      |                                                       |                                                        |                                      |  |  |  |  |
|-------------------|------------------------------|------|-------------------------------------------------------|--------------------------------------------------------|--------------------------------------|--|--|--|--|
| 100               |                              | 0.00 |                                                       |                                                        |                                      |  |  |  |  |
|                   | FLOW WATER JET               |      |                                                       |                                                        |                                      |  |  |  |  |
| Waterjet          | Memo                         | 0.00 |                                                       |                                                        |                                      |  |  |  |  |
| FLOW CNC Waterjet | 1-Cut as per Dwg D necessary |      | <input checked="" type="checkbox"/> Dwg Rev: <u>B</u> | <input checked="" type="checkbox"/> Prog Rev: <u>B</u> | <input type="checkbox"/> 2-Deburr if |  |  |  |  |
| <u>606.00</u>     |                              |      |                                                       |                                                        |                                      |  |  |  |  |

B11-4-28

|                 |                                         |      |  |  |  |  |  |  |  |
|-----------------|-----------------------------------------|------|--|--|--|--|--|--|--|
| 110             |                                         | 0.00 |  |  |  |  |  |  |  |
|                 | QC2- Inspect parts off machine FAI/FAIB |      |  |  |  |  |  |  |  |
| QC              | Memo                                    | 0.00 |  |  |  |  |  |  |  |
| Quality Control |                                         |      |  |  |  |  |  |  |  |

B11-4-28

|                 |                                   |      |  |  |  |  |  |  |  |
|-----------------|-----------------------------------|------|--|--|--|--|--|--|--|
| 120             |                                   | 0.00 |  |  |  |  |  |  |  |
|                 | QC8- Inspect parts - second check |      |  |  |  |  |  |  |  |
| QC              | Memo                              | 0.00 |  |  |  |  |  |  |  |
| Quality Control |                                   |      |  |  |  |  |  |  |  |

510469

count  
x80

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 68334**

Tuesday, April 12, 2011 10:01:11 AM



Page 2

Item ID: D3065-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Leg

Start Date: 4/12/2011 Start Qty: 80.00



Cust Item ID:

Required Date: 4/18/2011 Req'd Qty: 80.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



| Sequence ID/<br>Work Center ID          | Operation<br>Description                                           | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|-----------------------------------------|--------------------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130<br><br>HandFinish<br>Hand Finishing | Chemical Conversion Coat per QSI005 4.1<br><br>Memo                | 0.00<br><br>0.00     |         |        |              | 80            | 4             | 11-5-3           |                |
| 140<br><br>QC<br>Quality Control        | QC3- Inspect Part Finish<br><br>Memo                               | 0.00<br><br>0.00     |         |        |              | 80            |               | 11-5-3           |                |
| 150<br><br>Packaging<br>Packaging       | Identify as per dwg & Stock Location <i>Cum Fil Fr</i><br><br>Memo | 0.00<br><br>0.00     |         |        |              |               |               | 11/5/10          | 80             |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



**Work Order ID 68334**


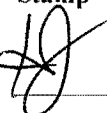
Page 3

Tuesday, April 12, 2011 10:01:11 AM

Item ID: D3065-5      Accept            Setup      Start        
Revision ID:      Stop        
Item Name: Step Leg  
Start Date: 4/12/2011      Start Qty: 80.00            Cust Item ID:  
Required Date: 4/18/2011      Req'd Qty: 80.00            Customer:

**Reference:**

Approvals:      Process Plan: \_\_\_\_\_      Date: \_\_\_\_\_      Tooling: \_\_\_\_\_      Date: \_\_\_\_\_      Run      Start        
QC: \_\_\_\_\_      Date: \_\_\_\_\_      SPC (Y/N): \_\_\_\_\_      Date: \_\_\_\_\_      Stop      

| Sequence ID/<br>Work Center ID                                                                                    | Operation<br>Description                                | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp                                                                      |
|-------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|-------------------------------------------------------------------------------------|
| 160<br><br>QC<br>Quality Control | QC21- Final Inspection - Work Order Release<br><br>Memo | 0.00<br><br>0.00     |         |        |              |               |               | 11/5/4           |  |

11-05-3  
(80)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, April 12, 2011 10:01:17 AM

Page 1

Work Order ID: 68334



Parent Item: D3065-5



Parent Item Name: Step Leg



Start Date: 4/12/2011

Required Date: 4/18/2011

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP: ☐C☐02.11.01☐Incorporated D3066-1 IPP☐KJ/RF  
IPP Rev:D Now on Water Jet 06-04-11 JLM  
IPP Rev:E Now manufactured with 6061-T6 06-05-25 JLM☐

| Component Item ID/<br>Item Name                                                                  | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit                                                                         | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|--------------------------------------------------------------------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------------------------------------------------------------------------------|--------------|---------------|----------------|--------|
| M6061T6S.080<br> |                        | Purchased     | No          |                     |                  | 100             | sf                 | 441.5000       | 0.825                                                                               | 69.47368     |               |                |        |
| 6061-T6 .080 Sheet                                                                               |                        |               |             |                     |                  |                 |                    |                |  |              |               |                |        |

B11-4-28

Location

Loc Qty

Loc Code

MAT021

441.5

116268

40.5

116700

65

117285

336

116700

80

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries





| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

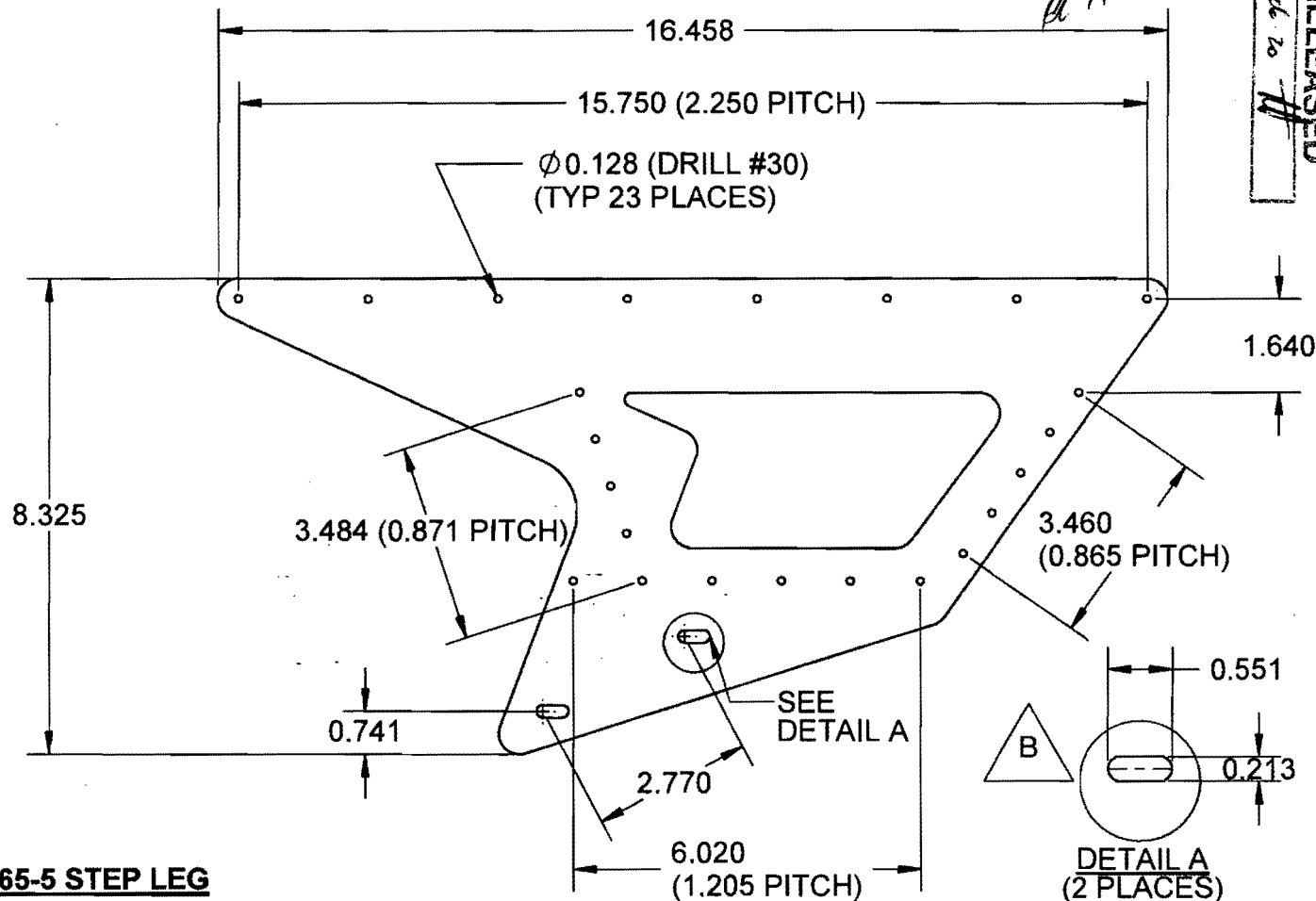
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**DART**

SHOP COPY  
RETURN TO  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 68334 *11-04-12*

RELEASED  
*06.05.23*



**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK  
(REF DART SPEC M6061T6S.080)  
OR  
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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|         |                   |             |           |                                                          |
|---------|-------------------|-------------|-----------|----------------------------------------------------------|
| DESIGN  | <i>CP</i>         | DRAWN BY    | <i>CB</i> | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |
| CHECKED | <i>PH</i>         | APPROVED    | <i>PH</i> | REV. B                                                   |
| DATE    | 06.05.23          | DRAWING NO. | D3065     | SHEET 4 OF 5                                             |
| TITLE   | STEP LEG ASSEMBLY | SCALE       | 1:3       |                                                          |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries